

SAS9432



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4931-1

Job Sheet 172553



Part No: D4931-1

Job Qty: 1 ea

Part Name: Engine Fitting (for acft models B2 & previous)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 4/20/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A SHEET 1 IPP REV:A NEW ISSUE 13-09-05 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		4/19/18	0.00	0.00	Start Up Machining-3		
100	Doosan	10 pcs		4/20/18	0.36	12.50	Doosan		
110	QC	10 pcs		4/20/18	0.00	0.00	QC2 Machining-3		
120	QC	10 pcs		4/20/18	0.00	0.00	QC8 Machining-3		
130	Packaging	10 pcs		4/20/18	0.00	0.00	Packaging3-2		
140	QC21-SA	10 Ea		4/20/18	0.00	0.00	QC21		

Part Op 100 - Machine as per folio FB210
Descriptions:

9-89

DAS

21

3-88

APR 11 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R2.000	303 Round Bar 2"	2.5000 ft (.25 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R2.000	3	63	0

Part Specifications

Specifications could not be found.

Plex 2/20/18 12:31 PM Dart.Gagnon.Michelle

DART AEROSPACE LTD		Work Order:	
Description: EAPS P2 Engine Fitting		Part Number:	D4931-1
Inspection Dwg: D4931	Rev: A	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.06 x 45°	+/-0.030 x +/-0.5°	0.057 x 45°	✓		MJP-04	vern
0.362	+/-0.010	0.365	✓			
0.088	+/-0.010	0.088	✓			
0.08	+/-0.030	0.075	✓			
0.25	+/-0.030	0.245	✓			
0.50	+/-0.030	0.498	✓			
Ø0.063	+0.004/-0.001	0.063	✓			
0.125	+/-0.010	0.130	✓			
0.424	+/-0.010	0.424	✓			
0.315	+/-0.010	0.315	✓			
0.185	+/-0.010	0.183	✓			
37°	+/-0.5°	37°	✓			
1.283	+/-0.010	1.283	✓			
1.250	+/-0.010	1.251	✓			
Ø0.472	+0.006/-0.001	0.475	✓			
Ø0.670	+0.008/-0.001	0.666	✓			
0.500	+/-0.010	0.500	✓			
0.950	+/-0.010	0.950	✓			
Ø0.609	+0.008/-0.001	0.609	✓			
0.938	+0.000/-0.005	0.936	✓			
1.804 Ref	+/-0.010	1.814	✓			
1-1/16-12 UN 2A	N/A	1 1/16-12 UN 2A	✓			
M18 x 1.5 Thread	N/A	M18 x 1.5	✓			
Wire Size 0.55	Max 1.099 ⁵ Min 1.093 ⁸	1.097	✓			
Wire Size 0.040	Max 0.737 ⁸ Min 0.732 ³	0.735	✓			

Measured by:	<i>MJP</i>	Checked by:		QC Inspector:	
Date:	18/04/06	Date:		Date:	

Engineering Approval: (if necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	14.08.27	New Issue	KJ	
B	16.05.30	Dimensions updated	KJ	<i>[Signature]</i>



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Container No: S059439



Part: D4931-1

Job No: 172553

Serial No/Batch: S059439

Revision:

Inspector:

Date: 04/10/18